

Date: Thursday, 10/11/2007 2:55:25 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INLET VALVE SHAFT
Job Number : 35143	
Estimate Number : 12257	
P.O. Number :	Part Number : D3474041
This Issue : 10/11/2007 S.O. No. :	Drawing Number : D3474 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 32041	Material :
Written By :	Due Date : 10/30/2007 Qty: 4 Um: Each
Checked & Approved By : <u>[Signature]</u> 07.10.11	
Comment : est rev. A 06.04.20 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34743	CONTROL ARM
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3474-3	Arm	B34390-1 B26122-3

PD 07-11-05 (4)

2.0	D34741	Shaft
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3474-1	Shaft	B35161

PD 07-11-05 (4)

3.0	AN960C416	washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	AN960-416	Washer	M5519

PD 07-11-05 (4)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: Weld assembly as per dwg D3474


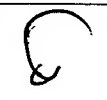

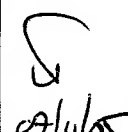
PD 07-11-05 (4)

PD →

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3474-041 PAR #: N/A Fault Category: Prod / Pre-As NCR: Yes No DQA: ✓ Date: 07/11/08
 QA: N/C Closed: ✓ Date: 07.11.08

NCR: 35143		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/08	4.0	D3474-3 was welded on back welds. L.C. Hummer error	 07.11.05	Remove and re weld as per QSI 004. Remove and weld in the inside of the Bracket. Acceptable for this fix only	07.11.06 PD	 07/11/06	 07.11.05	 07/11/05

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:55:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET VALVE SHAFT

Job Number: 35143

Part Number: D3474041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/11/05 (4)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/06 (24)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST101

AS 07/11/06

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.07

Job Completion



U 07.11.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

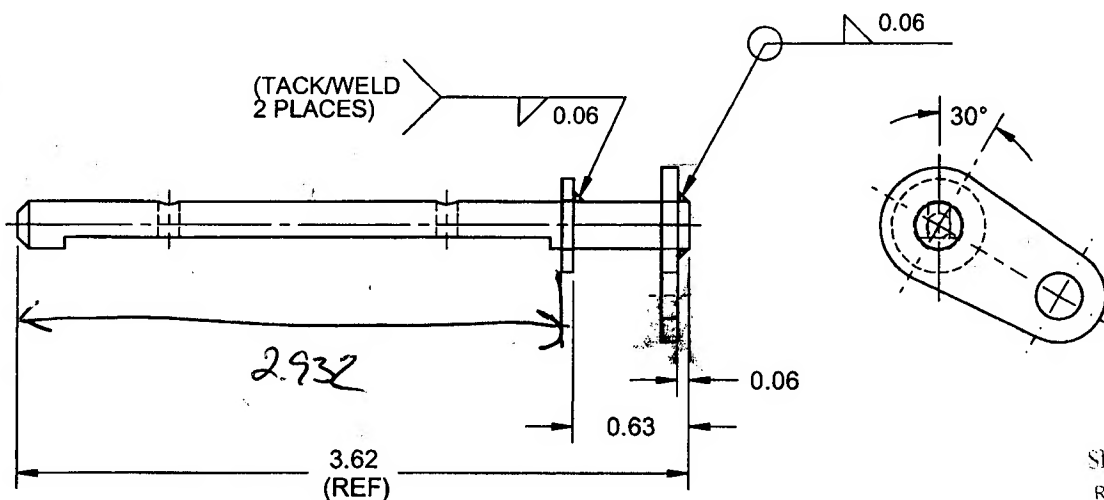
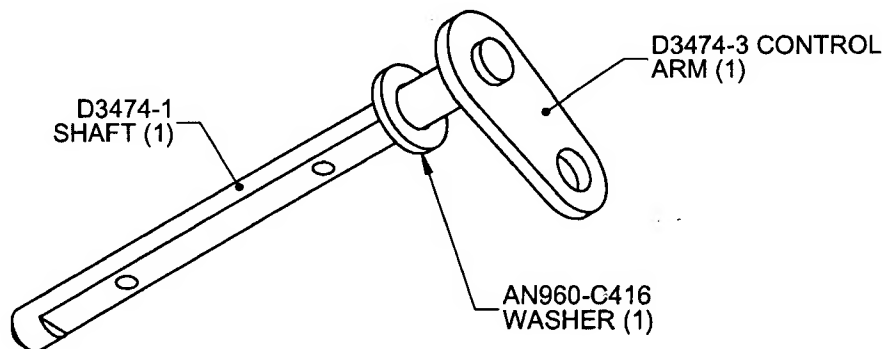
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1
A	06.01.23	NEW ISSUE	

[Handwritten] 06.04.03



D3474-041 INLET VALVE SHAFT

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NO. **35143**

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3474-041	INLET VALVE SHAFT
1	D3474-1	SHAFT
1	D3474-3	CONTROL ARM
1	AN960-C416	WASHER

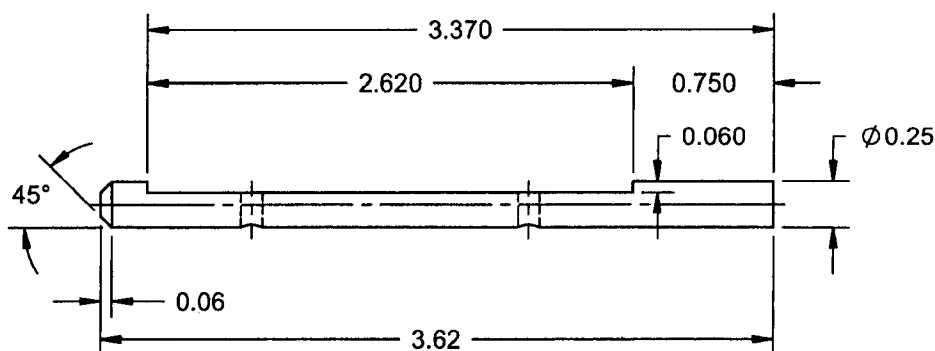
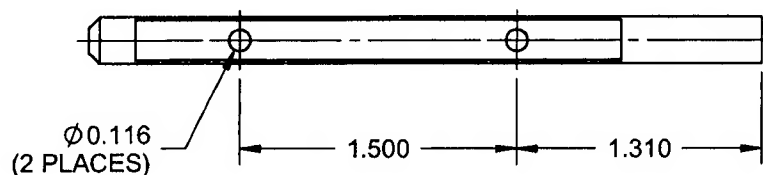
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DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

[Signature] 06.04.03



D3474-1 SHAFT

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR
(REF. DART SPEC. M303R0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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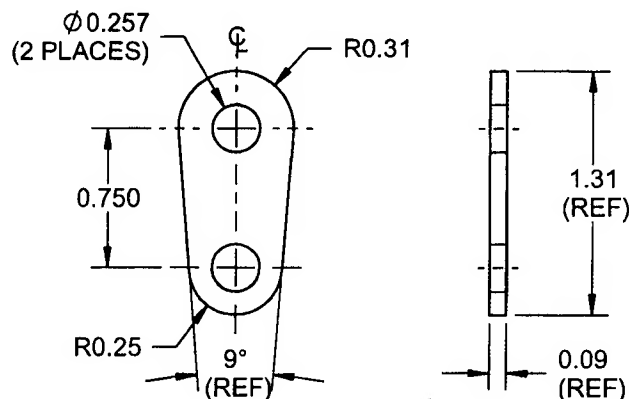
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DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

c6.04.03

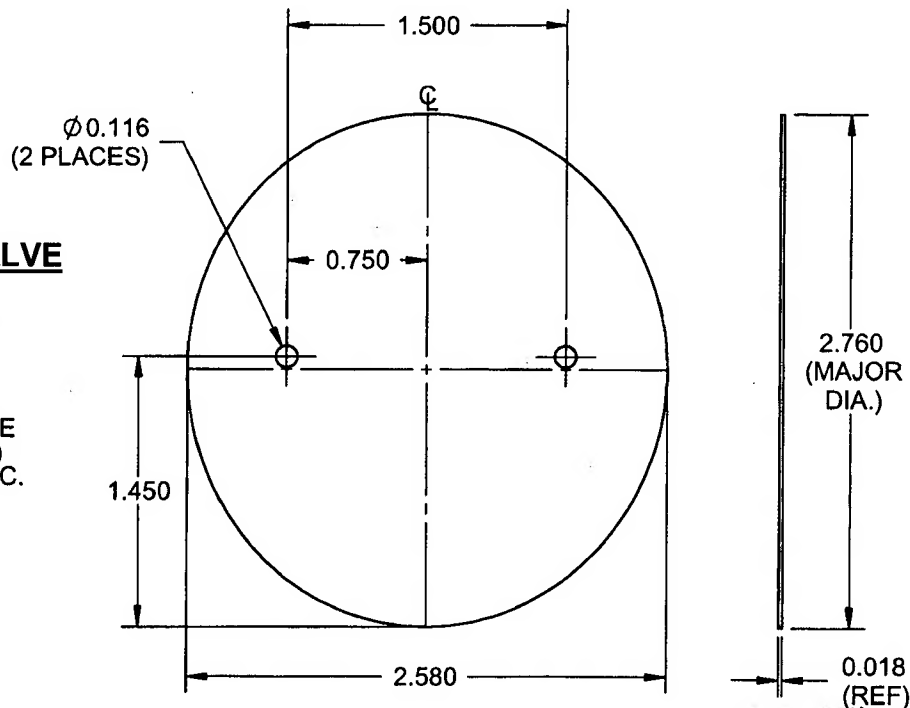
D3474-3 CONTROL ARM FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER
MIL-S-5019 (ANNEALED) 2B
FINISH 13 GAUGE SS
(0.090 THICK)
(REF. DART SPEC. M304S13GA)



D3474-5 BUTTERFLY VALVE FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS
SHEET PER
MIL-S-5019
(ANNEALED) 2B
FINISH 26 GAUGE
SS (0.018 THICK)
(REF. DART SPEC.
M304S26GA)



NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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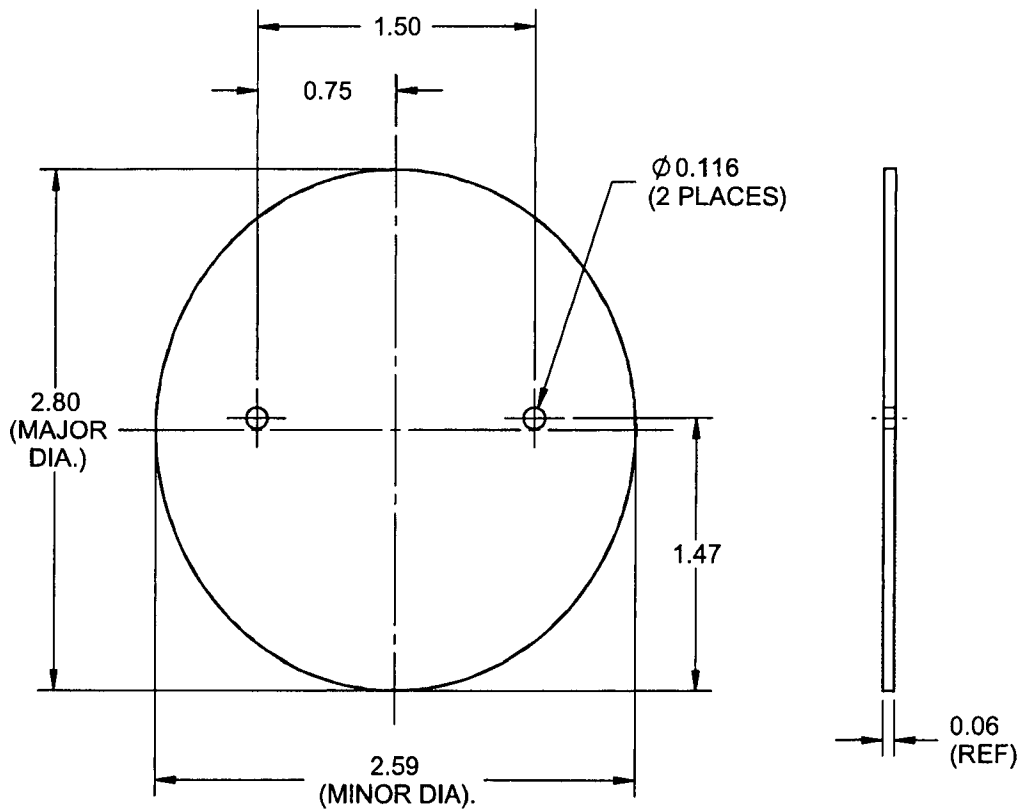
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DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

[Signature] 06.04.03



D3474-7 BUTTERFLY VALVE SEAL

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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